Date: Monday, 3/19/2007 8:13:01 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HEAT OUTLET DEFLECTOR
Job Number	: 31257		
Estimate Number	: 12156		
P.O. Number	: N/A	Part Number	: D34725
This Issue	: 3/19/2007 S.O. No. : N/A	Drawing Number	: D3472 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: 26173	Material	: N/A
Written By	:	Due Date	: 3/23/2007 Qty: 10 Um: Each
Checked & Approved By	: 07.03.19		
Comment	: est rev. A 06.02.02 new issue EC		
	est rev. B 06.03.29 added alodine EC		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S063	2024-T3 .063 sheet

Comment: Qty.: 1.1428 sf(s)/Unit Total : 11.4282 sf(s)
2024-T3 .063 sheet
Batch: M103321 ml 07 05 02 (10)

Seq. #:	Machine Or Operation:	Description :
2.0	WATER JET	FLOW WATER JET

Comment: FLOW WATER JET
Cut as per Dwg D3471
Dwg Rev: A
Prog Rev: A
ml 07 05 02 (10)

Seq. #:	Machine Or Operation:	Description :
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

ml 07 05 02 (10)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Seq. #:	Machine Or Operation:	Description :
4.0	QC8	SECOND CHECK

Comment: SECOND CHECK 07/05/03 (10)

Seq. #:	Machine Or Operation:	Description :
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
1- Deburr

2- Buff out scratches SAD 07/05/03 (10)

 Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______ **PAR #:** ______ **Fault Category:** ______ **NCR:** Yes / No (circled: No) **DQA:** [signature] **Date:** 07/05/03

QA: N/C Closed: ______ **Date:** ______

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/19/2007 8:13:02 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** HEAT OUTLET DEFLECTOR

Job Number: 31257 **Part Number:** D34725

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	07/05/03 (10)
7.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	07/05/03 10
8.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location:_______	05/03 (10)
9.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	(10) 07/05/03

Job Completion

07.05.03

Form: mprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

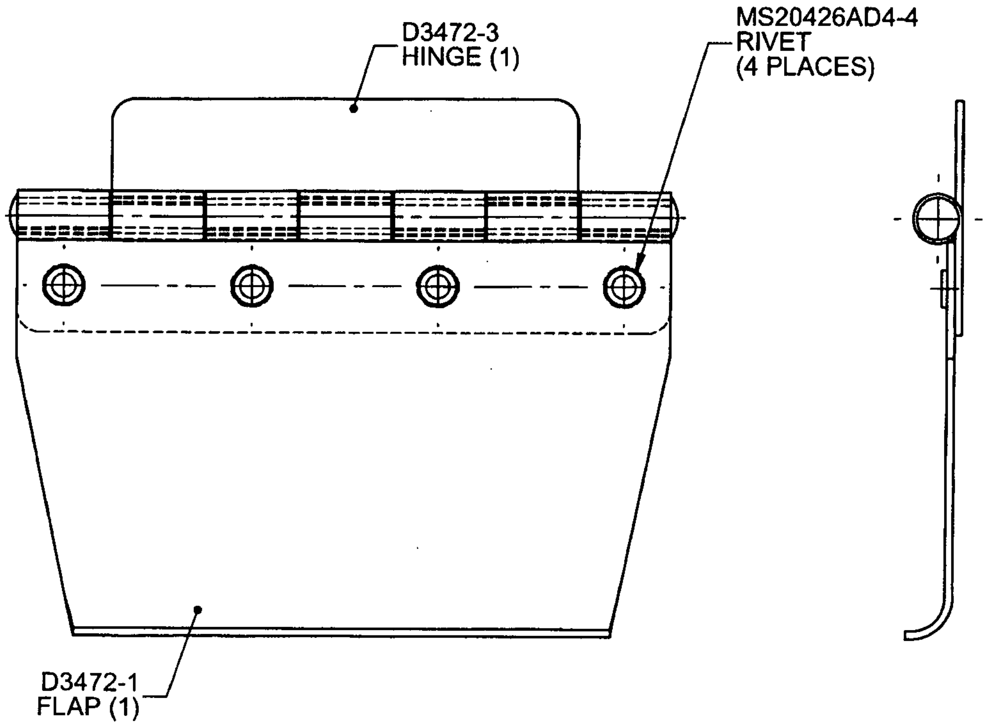
NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3472 REV. A SHEET 1 OF 4
DATE 06.01.17		TITLE HEAT OUTLET DEFLECTOR SCALE 1:1
A	06.01.17	NEW ISSUE

06.04.03



D3472-041 CABIN HEAT OUTLET DEFLECTOR

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31257

NOTES:

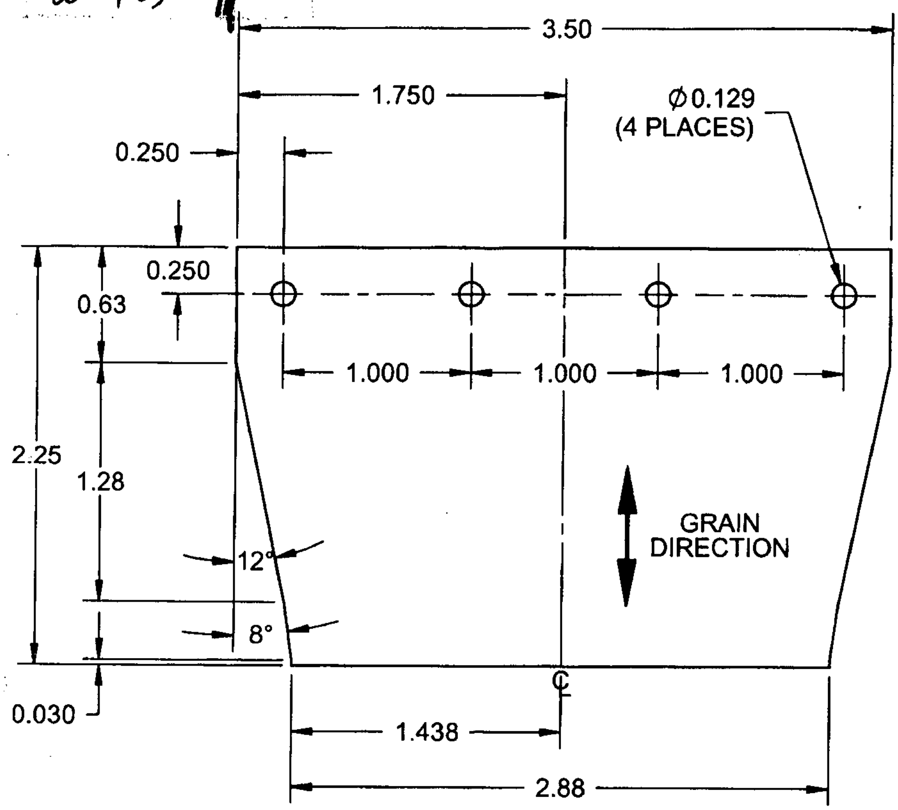
1) IDENTIFY WITH DART P/N D3472-041 USING FINE POINT PERMANENT INK MARKER
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	**D3472-041**	**CABIN HEAT OUTLET DEFLECTOR**
1	D3472-1	FLAP
1	D3472-3	HINGE
4	MS20426AD4-4	RIVET

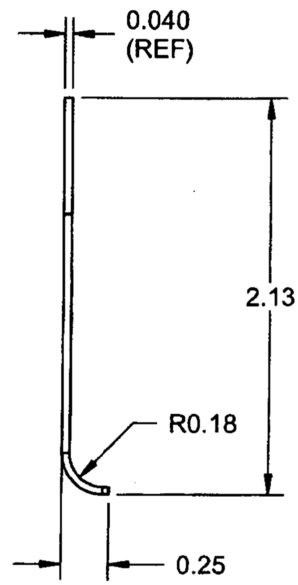
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3472 — REV. A — SHEET 2 OF 4
DATE 06.01.17		TITLE HEAT OUTLET DEFLECTOR — SCALE 1:1

DART

06.04.03



D3472-1F FLAP FLAT PATTERN



D3472-1 FLAP BENDING DETAIL

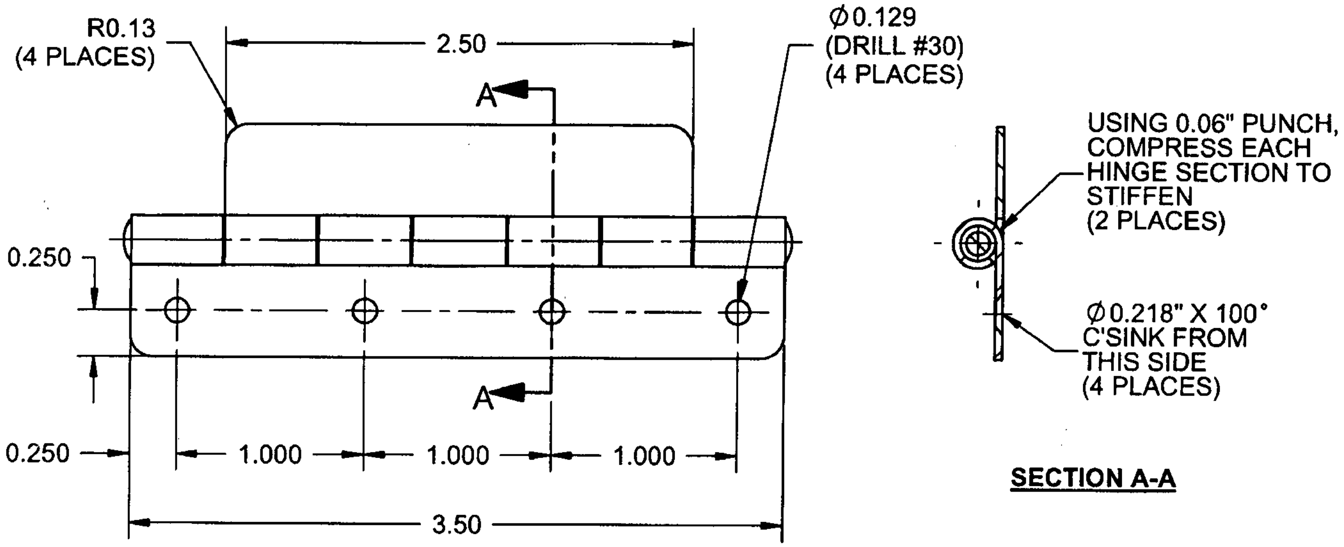
NOTES:

1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.040" THICK)
   PER QQ-A-250/4 OR AMS 4037
   (REF. DART SPEC. M2024T3S.040)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) PART IS SYMMETRICAL ABOUT CENTERLINE
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES 0.005 TO 0.010

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3472 REV. A SHEET 3 OF 4
DATE 06.01.17		TITLE HEAT OUTLET DEFLECTOR SCALE 1:1

DART

06.04.03



D3472-3 HINGE

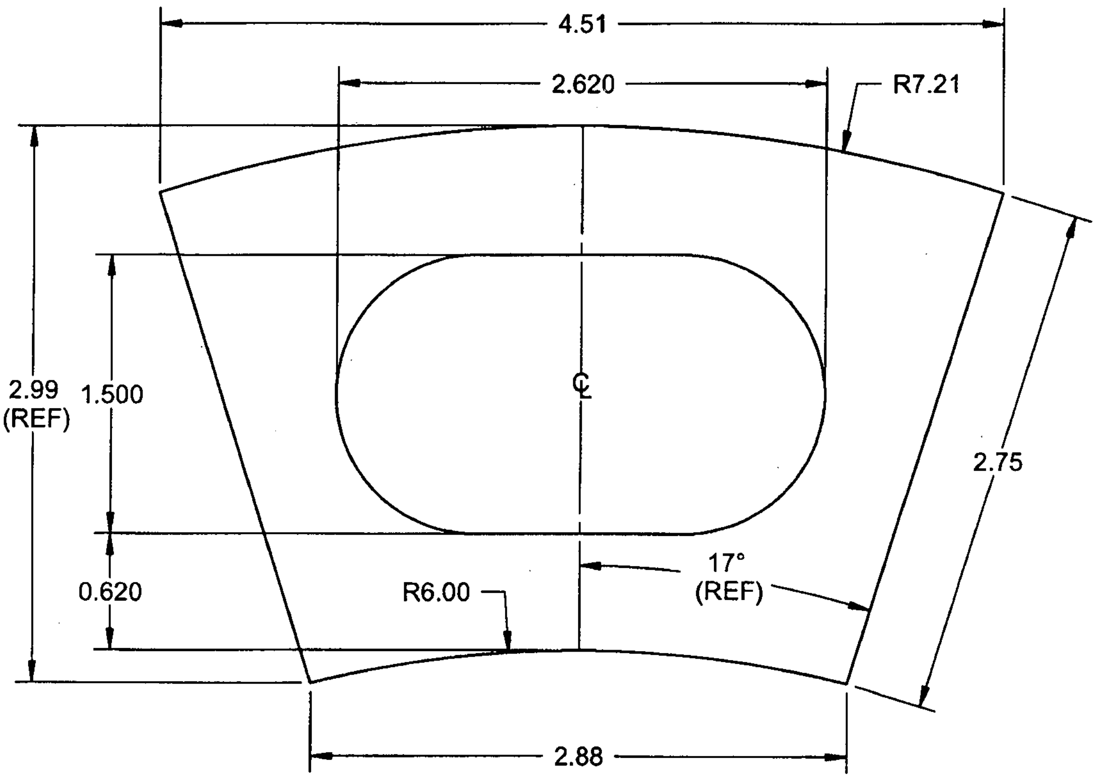
NOTES:

1) MAKE FROM MS20257-3 HINGE, MODIFIED AS SHOWN
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31257

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3472 — REV. A — SHEET 4 OF 4
DATE 06.01.17		TITLE HEAT OUTLET DEFLECTOR — SCALE 1:1

06.04.03



D3472-5 FLAT DOUBLER

NOTES:

1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063" THICK)
   PER QQ-A-250/4 OR AMS 4037
   (REF. DART SPEC. M2024T3S.063)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) IDENTIFY WITH DART P/N D3472-5 USING
   FINE POINT PERMANENT INK MARKER
4) PART IS SYMMETRICAL ABOUT CENTERLINE
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES
7) BREAK ALL SHARP EDGES 0.005 TO 0.010

DART AEROSPACE LTD | Work Order: 31257

Description: Heater Outlet Deflector | Part Number: D3472-5

Inspection Dwg: D3472 Rev: 1A | Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.51	+/-0.030	4.507	✓		VERN	
2.620	+/-0.010	2.622	✓		VERN	
2.99	+/-0.030	2.994	✓		VERN	
1.500	+/-0.010	1.495	✓		VERN	
2.88	+/-0.030	2.88	✓		VERN	
0.620	+/-0.010	0.625	✓		VERN	
2.75	+/-0.030	2.75	✓		VERN	

Measured by: M.M — Date: 07 05 02

Audited by: [signature] — Date: 07/05/03

Prototype Approval: N/A — Date: N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	